

706/407

DART AEROSPACE LTD		Work Order:	74223
Description: <i>Long Arm</i>		Part Number:	D3414-041
Dwg: D3414 Rev A.		Qty:	20 19
		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	U	05-09-07	20
2	PL	Issue P/O: 2008136 Label Cut per Dwg D3414-1 Ship or E-mail DXF file to Vendor. Possible Supplier: QND. Laser. Material Release Note is Required.	U	05-05-30	20
3	PL	Receive & Inspect for Transit damage Ensure that Material Release Note is attached.	C	05/07/15	20
4	QC6	Inspect dimensions as per template D2658T1 & Dwg D3414.	J	05-10-17	15 PTO
5	GA	Debur.	SB	05/10/18	19
6	GB	Form as per Dwg D3414 using DT 8254	SB	05/10/18	19
7	QC5	Inspect Work to Step #6	J	05-10-18	15
Rev	Date	Change	Revised By	Approved	

DART AEROSPACE LTD		Work Order:	24223
Description:		Part Number:	D 3414-041
Dwg:		Qty:	
		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
8	WIS	Pick: 1 D3414-3 Luf B24224 A/R SS Rod ^{N/A} 8 M17953 M13066 Weld as per. Dwg D3414. using location Fig DT 8484 AT 8208			
				CPL 05/10/19	19
9	QC9:5	Inspect Weld: work to Step = 8.		05/10/19	19
10	FP	Powder Coat Glass. White (4.3.5.1) as per. dent QST.0054.3		05/10/25	19
11	QC3	Inspect Powder Coat.		05/10/25	19
12	ST	Identify: Stock.		05/10/26	19
13	AC	Cost/Part 32.19 32.19		05/10/26	17
14	DC	Close w/o. Level 21.		05/10/26	19

Rev	Date	Change	Revised By	Approved

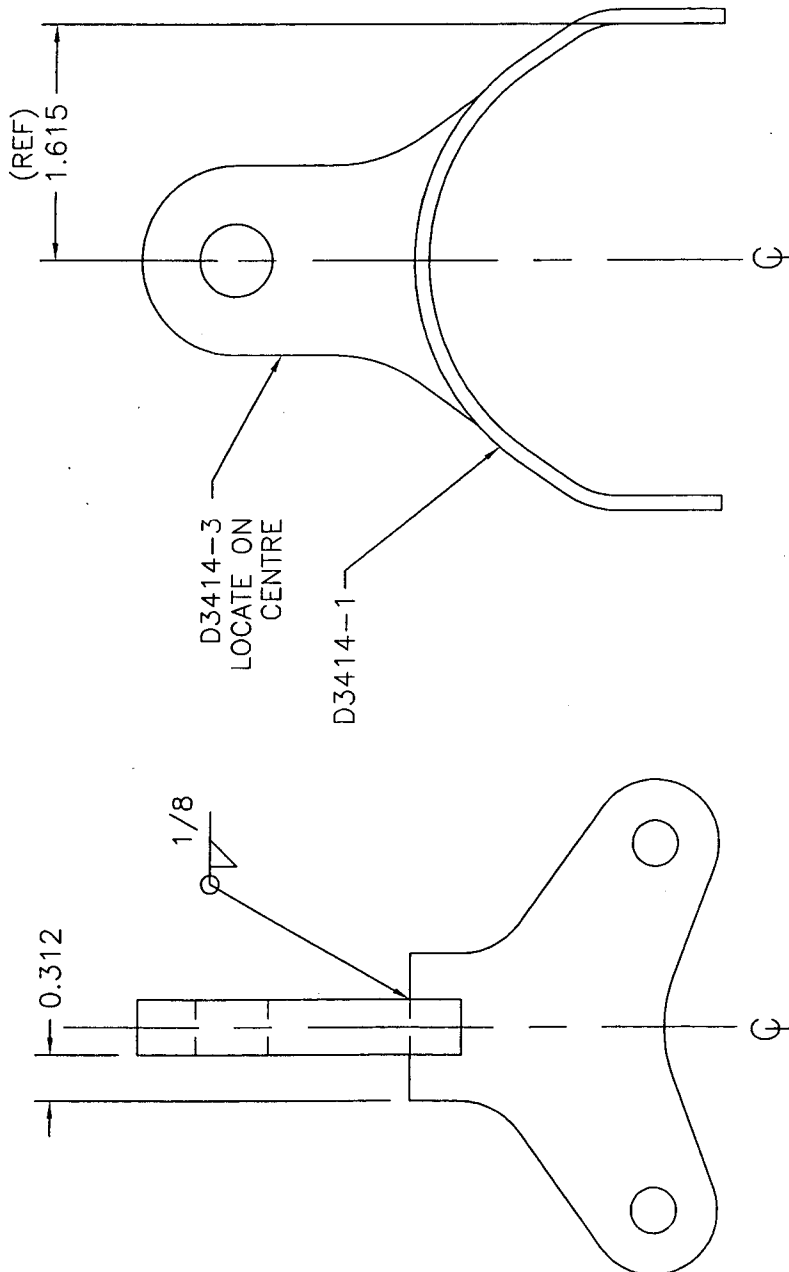
PRELIMINARY ISSUE



05.04.07

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO.	REV. A
				D3414	SHEET 1 OF 3
DATE				TITLE	SCALE
05.03.16				LUG ASSEMBLY	NTS
A	05.03.16			NEW ISSUE	

RELEASED
05.09.06



D3414-041 LUG ASSEMBLY

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE

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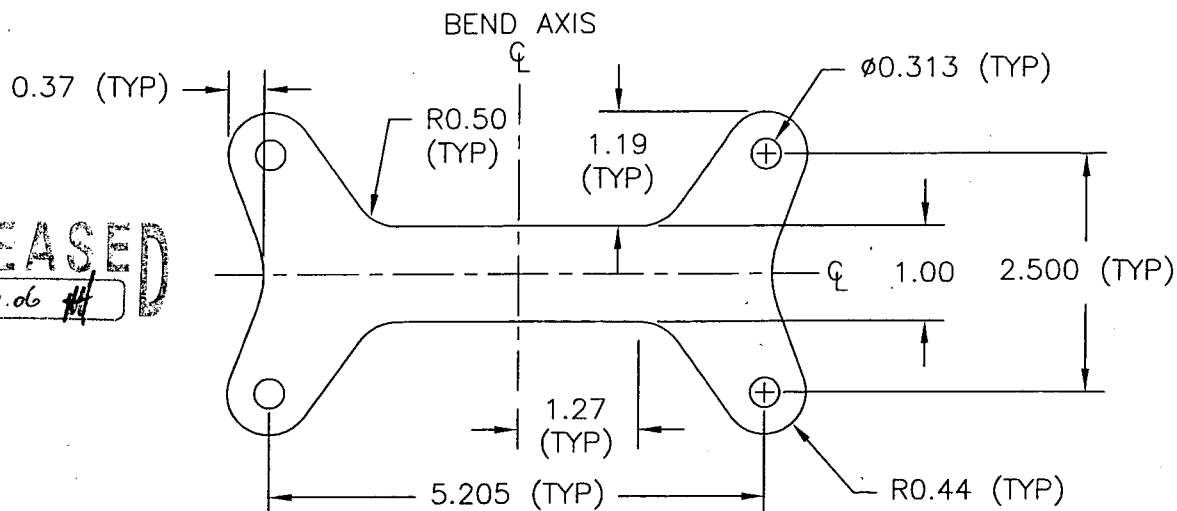
PRELIMINARY ISSUE



05.09.07

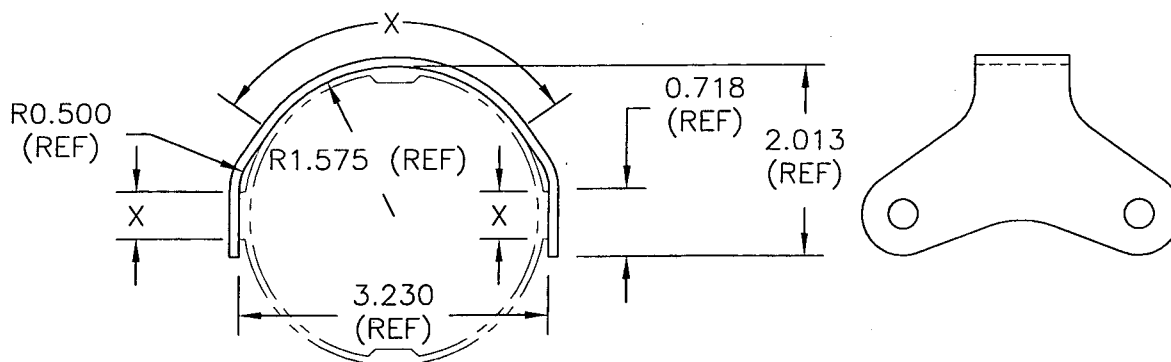
DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 2 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE 1:2

RELEASED
05.09.06 *[Signature]*



D3414-1 FLAT PATTERN

SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)



D3414-1 BEND DETAIL

D3414-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3414-1 LUG BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 0.100 THICK (12 GAUGE, REF DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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NORTH AMERICAN
STAINLESS

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 184035 02

Mail To:

ALASKAN COPPER & BRASS CANADA, INC.
P.O. BOX 3546
SEATTLE, WA 98124-3546

Ship To:

ALASKAN COPPER & BRASS CANADA, INC.
225 NORTH ROAD AVENUE
COQUITLAM, BC V3K3V7
CANADA

Date: 4/24/2003 Page: 1

Steel: 304/304L

Finish: HRAP

Your Order: V033868

NAS Order: AE 0249852 06

Corrosion: ASTM A262/01E, 180 Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL CONTINUOUS MILL PLATE, HRAP.
ASTMA240/01, A480/01, A666/00, ASMESA240/01, SA480/01, SA666/01
QQS766D-A X MGPRM, AMS5511G/AMS5513G XMRK, MIL4043B, AMD3, X CRNMEAS

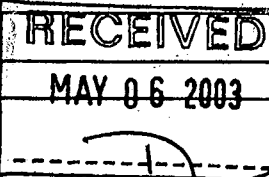
REMARKS:

Material free from mercury contamination. No weld repairs.

Product ID #	Coil #	Thickness	Width	Weight	-----Length-----	Mark	Pieces
A95688	* 0315L5 I	.2500	48.0000	3,665	120.0000	SHEET 1	9

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
15L5	.020	18.285	.556	1.753	.313	.046	8.369	.027	< .001	.355




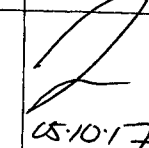
MECHANICAL PROPERTIES

Product ID #	Coil #	l d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail H Tail
A95688	0315L5	F T	86.53	43.78	45.21	86.50	88.00

Y4 304 #1 S.S.

QC ENGINEER

Donna P. L. 4/24/2003

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-10-17	4	Took 1x D3411-1 to use for template D2658 T1.		05-10-17	1		 05-10-17

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/10/26

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____